Work Order	c ID 74510 03, 2011 2:37:05 F	PM									Page 1
Item ID: I Revision ID:	03536-23		A	Accept				s	etup Stai	1 (8811181 1	
	asket				•				Sto	р	
Start Date: 9 Required Date: 1		Qty: 12.00 l Qty: 12.00			Cust Item I Customer:	D:					
Reference:							_	-	S.		18112 (2) (12) (88)
	Process Plan: <u>M</u> QC:	.L.J	Date: 11/10/03	Tooling: SPC (Y/N):		ate:		ŀ	tun Stai Sto		
Sequence ID/ Work Center ID	Opera Descri			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision N	br									· · · · · · · · · · · · · · · · · · ·
D3536	Rev A										-
Waterjet FLOW CNC Waterjet	FLOW	WATER JET Memo 1-Cut as per Deburr if nec		0.00 0.00 Prog Rev:	<u>A</u> = ==================================			<u></u>	-10-11	(13)	<u> </u>
110 QC Quality Control	QC2- In	nspect parts off ma	achine FAI/FAIB	0.00					11-10-11) - ——
120 	QC8- In	nspect parts - seco	nd check	0.00	110112			412)		·

Quality Control

W/O:			W	ORK ORDER CHANG	iES				
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DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng		Sign & Section C		Chief Eng	QC Inspector
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Work Order ID 74510

Monday, October 03, 2011 2:37:05 PM



Page 2

Item ID:

D3536-23

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Gasket

Required Date: 10/14/2011

9/30/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

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QC:

Process Plan: Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location;

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool # Plan Accept Code

Qty

. · . .

Reject Qty

Reject Insp. Number

Stamp

140

QC21- Final Inspection - Work Order Release

0.00

Quality Control

0.00

									
W/O:	-		WO	RK ORDER CHANGI	ES			***	
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Picklist Print

Monday, October 03, 2011 2:37:09 PM

Work Order ID: 74510

Parent Item:

D3536-23

Parent Item Name: Gasket



Start Date: 9/30/2011

Required Date: 10/14/2011

Page 1

Required Qty: 12.00

Start Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	636.8500	1.3365	17.82			·
										19	311-10-11	·	

NEOPRENE SHEET 0.063

<u>Location</u>	Loc Qty	Loc Code	÷	
MAT052	636.85			
117295	55.68			
118026	127.87			(12)
118663	73.3			
119130	380		119130	

	-								
W/O:			WC	ORK ORDER CHANGE	S				•
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NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCR)			
DATE	STEP	Description of NC		1 B	Verific		Approval	Approval	
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		·							

DART AEROSPACE LTD	Work Order:	74510
Description: Gasket	Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototy	ре
<u>X</u>	First Article	Prototy	pe

Drawing	Talanana	Actual	Accord	Daiset	Method of	C
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
52.85	+/-0.030	53.85	<u> </u>		T BUI	
48.20	+/-0.030	48.26	V		7	
44.70	+/-0.030	44.70			7	
39.31	+/-0.030	39.31	C		7	
33.92	+/-0.030	33, 92	C		7	
28.53	+/-0.030	28.53			7	
23.14	+/-0.030	23.14	b		+	
17.75	+/-0.030	17.75	L		7	
14.25	+/-0.030	14.25	~		7	
9.50	+/-0.030	.9,50	U.		1	
4.75	+/-0.030	4.78	•		1	
8.00	+/-0.030	8.00	<u></u>		4	
16.00	+/-0.030	16.00	L		7	
24.00	+/-0.030	24.00			1	
32.00	+/-0.030	3∂.∞	ملا		7	
39.00	+/-0.030	39.60	*		T	
48.00	+/-0.030	48.00	X		7	
0.30	+/-0.030	- 303	×		V	
0.30	+/-0.030	.307	7		V	
1.89	+/-0.030	1.888	7		V	
Ø0.19	+0.005/-0.001	,ાલ્પ	>=		V 1307	

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-10-11	Date: 10/0/12	Date:	N/A

Rev	Date	Change	Revised,by	/ Approx/ed
Α	07.03.14	New Issue	KJ/JLM	- (41)

	-								
W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	_ Date: _	
		esolution:	Disposition	•	QA: N/C Closed:			Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
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DATE 06.10.25

06.10.25

NEW ISSUE

GASKET

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D3536

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DRAWING NO

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DART

AEROSPACE

NO.

26.65 23.15 21.15 17.65 13.40 - 0.90 - 5.65 1.89 3.90 DETAIL #0.19 (TYP 3 PLS)

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14.07 9.15
DETAIL A - 3.90 - 3.90
(TYP 4 PLS) 14.00 20.00
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COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:			WORK ORDER CHANGES							
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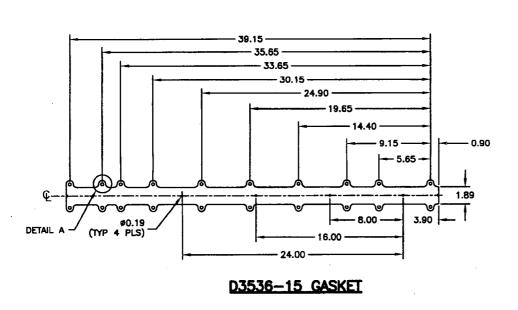
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DETAIL A

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DUROMETER (REF DART SPEC. M-NEO60-S.063)
2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT €
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

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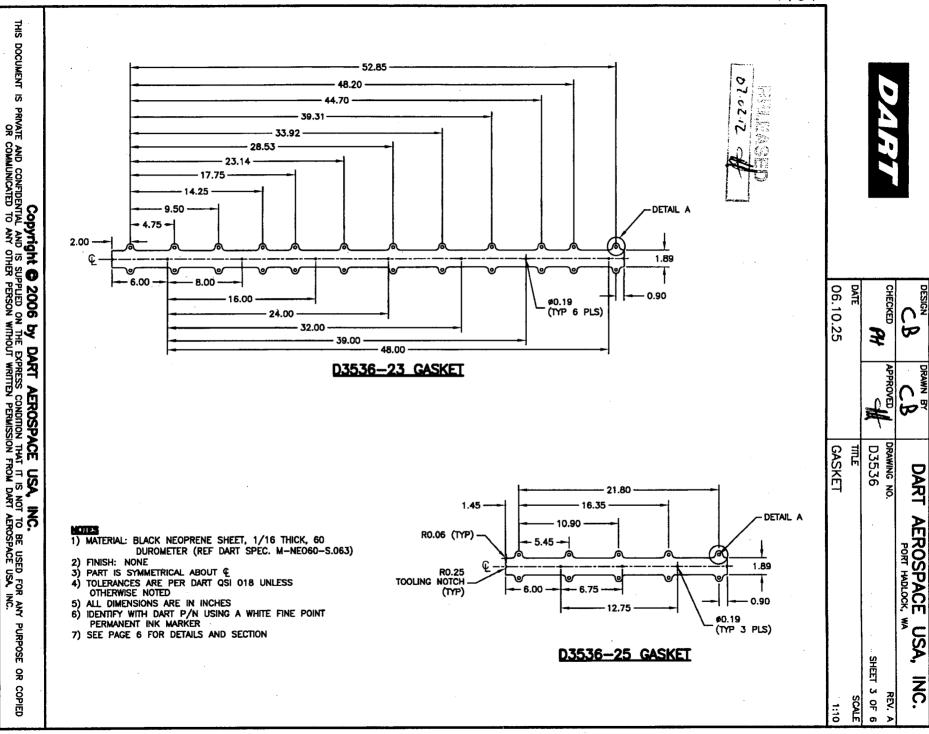
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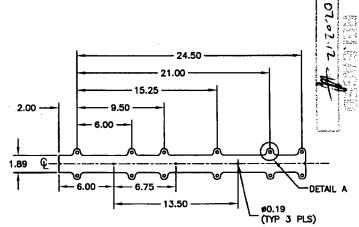
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

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- 2) FINISH: NONE

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 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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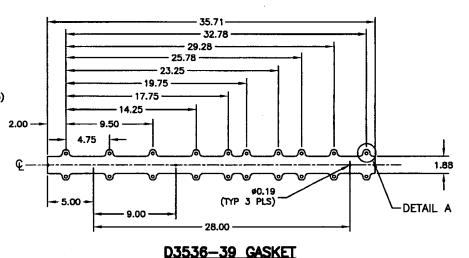
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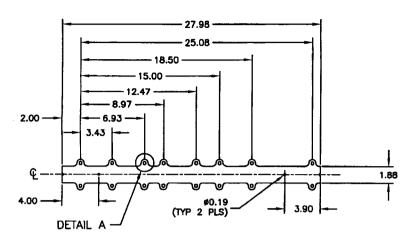
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- 2) FINISH: NONE
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 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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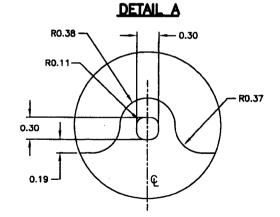
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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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W/O:			WORK ORDER CHANGES								
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